

Inf 11/20/12 20

Work Order ID 79627

79627

Page 1

February-01-12 11:17:54 AM

Item ID: D206-667-107BL

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Mid Fwd, Blue

Start Date: 30/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 12/02/01 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D206-667-147

A (DEO)

DSI9565

A

IIN-D206-667

D

100

0.00

100

DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels as per PPP D206-667-107 chg 002

110

0.00

110

Packaging

Packaging

Pick Kit

Packaging

Memo

0.00

ml 12-02-23 (1)
HAR ML5 12-2-22

MO

12/2/6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79627

79627

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February-01-12 11:17:54 AM

Item ID: D206-667-107BL

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Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Mid Fwd, Blue

Start Date: 30/01/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120	BENDING MACHINE - CROSSTUBES								
CNC Bend 2	Memo	0.00							
CNC Alpha 160 Bender	Bend tube as per Dwg D206-667-147 using CNC bender program								
130	QC15- Crosstube Dimensional Check	0.00							
130									
QC	Memo	0.00							
Quality Control									

JW
MO
RM

12-2-7

8/26/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Crosstubes	0.00							
140									
Crosstubes	Memo	0.00							
Crosstubes	1-Drill holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-147. Drill all (3) top holes.								
	3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.								
	4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-147. Drill only the top (2) holes.								
	5-Drill pilot holes as per Dwg D206-667-147. Drill only the top (2) holes.								
	6-Drill Fwd rivet holes using drill Jig DT8787 fwd as per Dwg D206-667-147. Note: Fwd side has 3x top holes.								
	7-Drill Aft rivet holes using drill Jig DT8787 fwd as per Dwg D206-667-147.								
	8-C'sink holes as per Dwg D206-667-147. Allow rivet to sit below surface to compensate for paint.								
	9 -Scribe part # and batch # using vibrating stylus as per Dwg D206-667-147 Inside of Cuff(Donot engrave on outside of tube)								
	10-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-147								

TW/RM

12-2-8

TW

12-2-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

Crosstubes Chemical Conversion

0.00

150

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

TW

12-2-10

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

8/12/10

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

8/12/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Outsource process - NDT per QSI038 4.1

0.00

180

Outsource2

Memo

0.00

Outsource process - NDT

CROSSTUBES

7/0.16169

CL 12102110 ①

190

Packaging

0.00

190

Packaging

Memo

0.00

Packaging

Ensure copy of NDT results attached to work order.

12/2/10 ①

200

QC5- Inspect part completeness to step on W/O

0.00

2000

QC

Memo

0.00

Quality Control

8/26/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Crosstube Mid Fwd, Blue

Start Date: 30/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210		0.00							
210	SprayPaint								
SprayPaint	Memo	0.00							
Spray Painting	PRIME B <u>117319</u>								
	DELFLEET BLUE B <u>118395</u>								
	CLEAR DELFLEET B <u>118093</u>								
220	QC14- Inspect Spray Paint	0.00							
220									
QC	Memo	0.00							
Quality Control	Wrap in plastic bag to protect from scratches								

AS 12-2-13

35 12-02-14 (x1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Revision ID:

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Item Name: Crosstube Mid Fwd, Blue

Start Date: 30/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

0.00

230

Crosstubes

Crosstubes

Memo

0.00

1-Abrade mating surfaces of support and crosstube with 400 grit sandpaper,
clean the area with 4105S wash 'n' wipe

2-Install supports with Proseal 890 per DSI9565 and QSI 015

A/R Proseal 890 Batch: 120072

3- Torque bolts as per dwg

4-Install nut plates as per Dwg D206-667-147. Touch-up rivet heads with Imron
paint.AS 12-2-14

240

QC5- Inspect part completeness to step on W/O

0.00

240

QC

Memo

0.00

Quality Control

12 02 22 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 79627***79627***

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February-01-12 11:17:54 AM

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Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Crosstube Mid Fwd, Blue

Start Date: 30/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

Sp 12-02-23

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

12 02 23

270

Packaging

0.00

270

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-667-107

Location:

PPP Rev: A

12/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79627***79627***

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Item ID: D206-667-107BL

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Crosstube Mid Fwd, Blue

Start Date: 30/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

12/2/23

mf
12-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

February-01-12 11:17:58 AM

Page 1

Work Order ID: 79627

79627

Parent Item: D206-667-107BL

*D206-667-107BL *

Parent Item Name: Crosstube Mid Fwd, Blue

Start Date: 30/01/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: revA 11.01.13 New Issue EC verified by:DD
11.08.08 PER ECN 11-615 DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D206-667-147TRN

Manufactured

No

110

Each

2.0000

1

1

D206-667-147TRN

**

Crosstube Assembly, Mid Fwd

Location

Loc Qty

Loc Code

LG003

2

78669

1

D2873-043

Manufactured

No

230

Each

26.0000

2

2

D2873-043

**

Nut Plate Assembly

Location

Loc Qty

Loc Code

LG052

26

72644

2

73605

4

75010

20

D2873-045

Manufactured

No

230

Each

19.0000

2

2

D2873-045

**

Nut Plate Assembly

*79318

Location

Loc Qty

Loc Code

LG052

19

74985

19

D2891-1

Manufactured

No

230

Each

36.0000

2

2

D2891-1

**

2.25 Support

Location

Loc Qty

Loc Code

LG052

36

72822

16

75476

20

① MD 12/2/6

AS 12-2-13

AS 12-2-13

AS 12-2-14

②

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 79627

79627

Parent Item: D206-667-107BL

*D206-667-107BL *

Parent Item Name: Crosstube Mid Fwd, Blue

Start Date: 30/01/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3595-063-395

Manufactured No

230 Each

90.0000

4 4

D3595-063-395

RUBBER CUSHION

**

AS 12-2-14

Location

Loc Qty

Loc Code

MAT052

90

70975

13

74300

77

4

cut (4)0.063" X 3.95"

MS20601-AD4W8

Purchased No

230 Each

393.0000

14 14

MS20601-AD4W8

RIVET

**

AS 12-2-13

Location

Loc Qty

Loc Code

LG

100

108521

100

LG051

115

117106

7

117381

3

117979

3

118572

2

119107

100

ST322

178

118454

78

120450

100

4

10

MS21920-20

Purchased No

230 Each

102.0000

4 4

MS21920-20

Clamp (per MIL-DTL-8783C)

**

AS 12-2-14

Location

Loc Qty

Loc Code

LG050

102

116799

10

119386

42

120475

50

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 79627

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Parent Item: D206-667-107BL

***D206-667-107BL ***

Parent Item Name: Crosstube Mid Fwd, Blue

Start Date: 30/01/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-30A Purchased No

250 Each

129.0000

4

4

AN5-30A

BOLT

**

m 120717 SP SP

Location

Loc Qty

Loc Code

ST339

129

117514

7

118706

47

120423

75

AN5-32A Purchased No

250 Each

274.0000

4

4

AN5-32A

Bolt

**

m 120717 SP SP

Location

Loc Qty

Loc Code

ST339

274

118422

2

118628

22

118983

25

119328

100

119862

50

120423

75

AN5-7A Purchased No

250 Each

2,801.000

10

10

AN5-7A

Bolt

**

SP SP

Location

Loc Qty

Loc Code

ST337

2801

118422

1

119017

2800

AN960JD516 NAS1149D0563J Purchased No

250 Each

0.0000

18

18

AN960JD516

Washer

**

m 119717 SP SP
12-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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***D206-667-107BL ***

Parent Item Name: Crosstube Mid Fwd, Blue

Start Date: 30/01/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN970-4

Purchased

No

250

Each

148.0000

12

12

AN970-4

Washer

**

SP

SP

Location

Loc Qty

Loc Code

ST344

148

115936

11

116900

1

117795

61

120308

75

12x

MS21042L5

Purchased

No

250

Each

1,916.000

4

4

MS21042L5

Nut

**

SP 12-02-23

SP

Location

Loc Qty

Loc Code

ST300

1916

116105

5

116548

43

117611

46

~~118179~~

322

119109

1500

4x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Item	Qty -147	Part Number	Description
1	X	D206-667-147	CROSSTUBE ASSEMBLY (206L MID FWD)
2	1	D6002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4VW8	RIVET (OR NAS9302B-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 99.84±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-147" AND BATCH NUMBER ON
INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS).
- 7) WEIGHT: 15.0 lbs (-507 = 12.84)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI
015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE
THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS
ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP
REF

UNCO
SUB

79627 M.L.J
12/02/01

DEO ATTACHED

EQW #11-615
11.07.28

UNDER REVIEW

RELEASED
2011-05-23
JN

A	NEW ISSUE	CP	10.11.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.23		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D206-667-147	REV. A SHEET 1 OF 4
TITLE CROSSTUBE ASSY (206L MID FWD)	SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

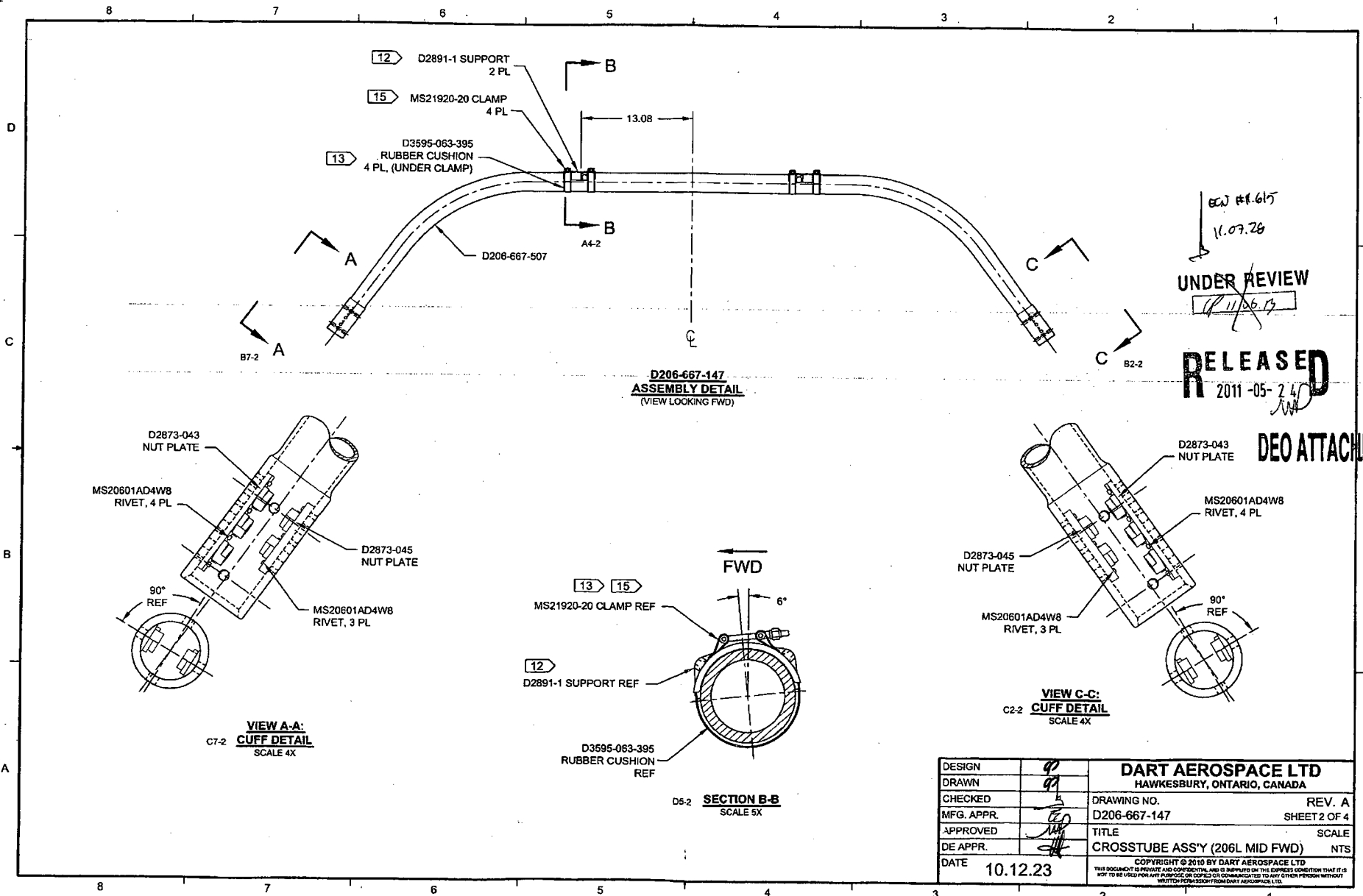
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79627



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D206-667-147	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (206L MID FWD)	NTS
DATE	10.12.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

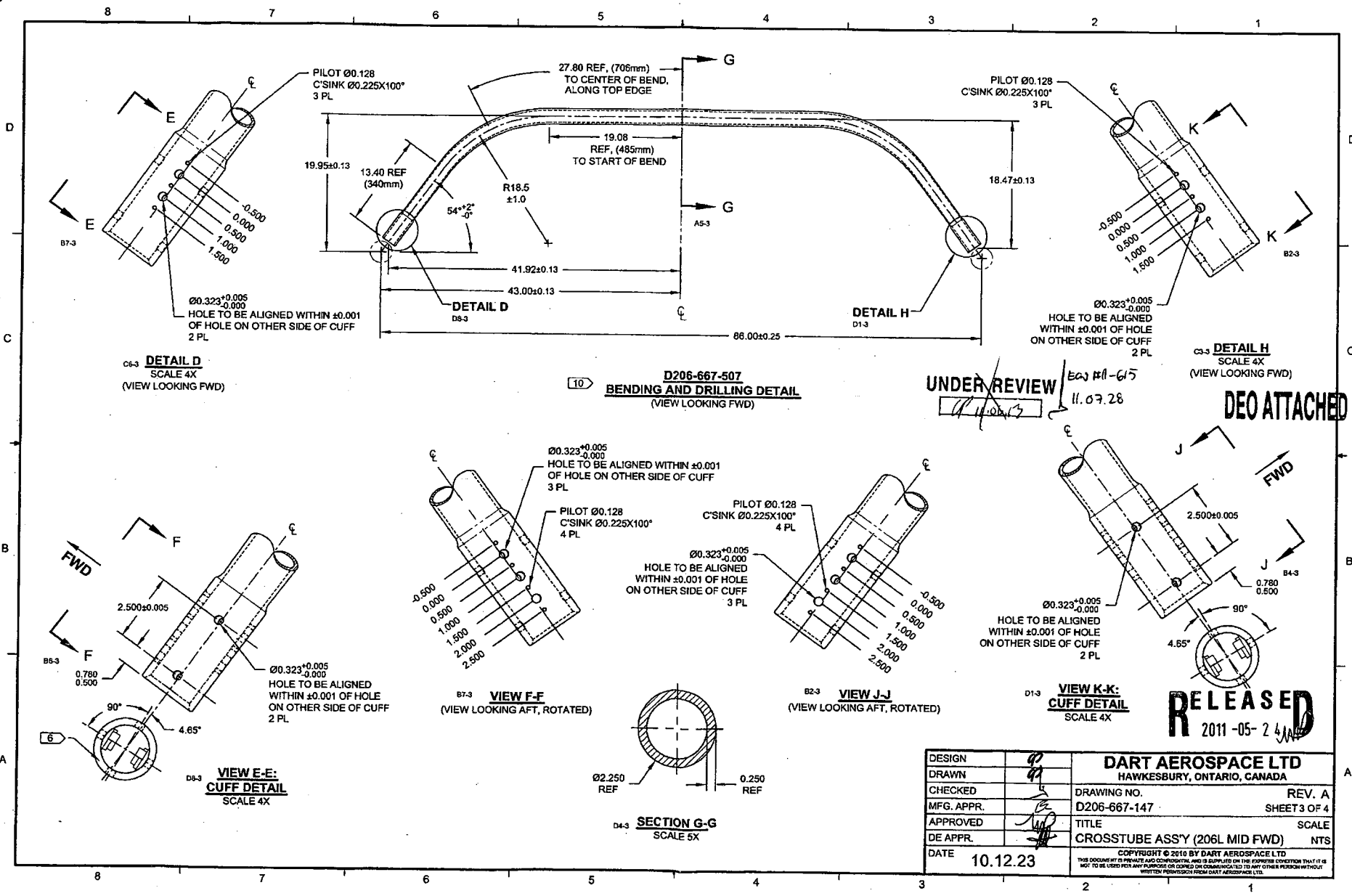
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79627



DESIGN	90	DART AEROSPACE LTD	
DRAWN	91	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.	93	D206-667-147	SHEET 3 OF 4
APPROVED	94	TITLE	SCALE
DE APPR.	95	CROSSTUBE ASSY (206L MID FWD)	NTS
DATE	10.12.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

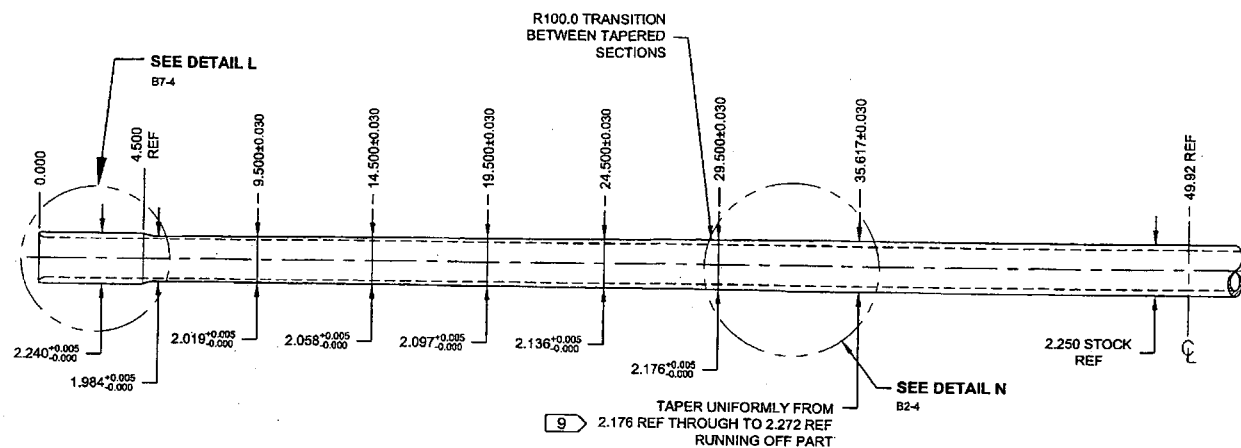
NOTE: Date & initial all entries

79627

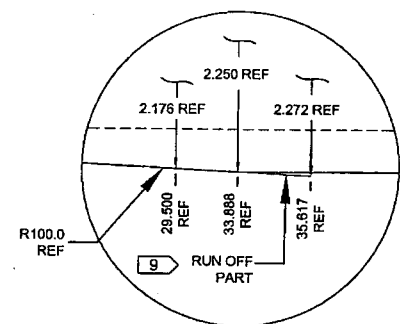
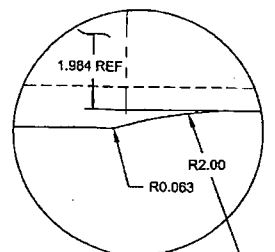
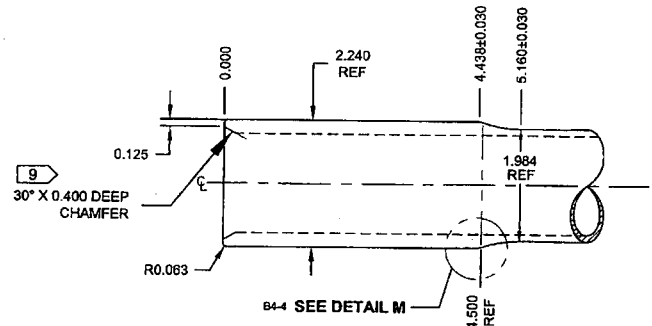
UNDER REVIEW

11.06.13

ECN # 11-615
11.07.28



TURNING DETAIL



DEO ATTACHED

RELEASED
2011-05-23

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D206-667-147	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (206L MID FWD)	NTS
DATE	10.12.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79627

DRAWING NO. D206-667-147	TITLE CROSSTUBE ASS'Y (206L MID FWD)	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D206-667-147-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN qp	CHECKED ADS	MFG. APPR. [Signature]	APPROVED [Signature]		DE APPR. [Signature]		
DATE 11.07.15	DATE 11.07.20	DATE 11.07.21	DATE 11/07/21		DATE 11.07.21		

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

Item	Qty -147	Part Number	Description
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
---	-----	----------------	---

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

12) TO INSTALL D2891-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.

15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.

15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-07-28
[Signature]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79627

DART SERVICE INSTRUCTION

TO AMEND INSTRUCTIONS FOR CONTINUOUS AIRWORTHINESS ICA-D206-667 Rev. 3 OR LATER
 REF. CANADIAN STC: SH01-5
 REF. FAA STC: SR01304NY
 REF. EASA STC: EASA.IM.R.S.01179

PURPOSE:

The supports on the following crosstubes are now installed using Proseal instead of Magnobond:

D206-667-101 @ CHG 004	D206-667-203 @ CHG 004
D206-667-103 @ CHG 005	D206-667-207 @ CHG 002
D206-667-107 @ CHG 002	D407-667-105 @ CHG 004
D206-667-201 @ CHG 004	

CHANGE:

For the crosstubes listed above, section 32.4 of ICA-D206-667 is amended as follows. Use Figures 32-4 to 32-8 of ICA-D206-667 for further reference. For crosstubes of an earlier change number, it is recommended that if the supports are removed, the supports should be reinstalled using the procedure listed below.





32.4 SUPPORT INSTALLATION

- 32.4.1 Locate the area on crosstube for installation of support (ref. Figures 32-4 to 32-8 of ICA-D206-667). For D206-667-101/-103/-107/-201 and D407-667-105 crosstubes, the outward face of the support tabs should be 13.08" (332mm) from the crosstube center. For D206-667-203/-207 crosstubes, the outward face of the support tabs should be 10.03" (255mm) from the crosstube center. Ensure paint finish of crosstube is intact; touch up as required per Chapter 5 (5.3.9) of ICA-D206-667.
- 32.4.2 If present, remove any paint/primer on bottom of supports. Abrade mating surfaces of support and crosstube with 400-grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe until there is no residue.
- 32.4.3 Ensure a layer of 3M Scotch-Weld 2216 B/A Epoxy Adhesive is on the bottom of the support. If required, either apply or touch-up support to have a 0.03" to 0.05" thick layer of adhesive over the entire mating surface. Allow supports to cure for 24 hours.
- 32.4.4 Abrade mating surfaces of support (after cure) and crosstube with 180-grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe until there is no residue.
- 32.4.5 Apply a 0.04" to 0.07" thick layer of Proseal 890 Class B or AMS-S-8802 Class B sealant underneath applicable support and install support.
- 32.4.6 Install the clamps opposite to crosstube support as shown in Figures 32-4 to 32-8 of ICA-D206-667. Install rubber cushions underneath each clamp around the bottom circumference of the crosstube up to the crosstube centerline. Torque clamps 80-100 in-lb (9.0-11.3 Nm). It is acceptable to use smaller or larger sized MS21920-XX clamps than those listed in ICA-D206-667, ensure that after torquing the clamps per this instruction, the nuts are in safety but not bottomed out.
- 32.4.7 Prior to installing crosstube on aircraft, allow supports to cure for 72 hours and recheck torque on clamps.

CANADA
 DEPARTMENT OF TRANSPORT
 AIRCRAFT CERTIFICATION
 BRANCH
 DAO # 01-O-01

APPROVED
 BY: 
 D. SHEPHERD (DE # 02)

DATE: 11.07.20
 CERT. NO.: SH01-5
 ISSUE NO.: 3

A	NEW ISSUE	CP	11.07.15
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9565	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT INSTALLATION CHANGE	NTS
DATE	11.07.15	COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

B79627

DART AEROSPACE LTD		Work Order:	
Description: Crosstube		Part Number:	D
Inspection Dwg: D		Rev:	
		Page 1 of 1	

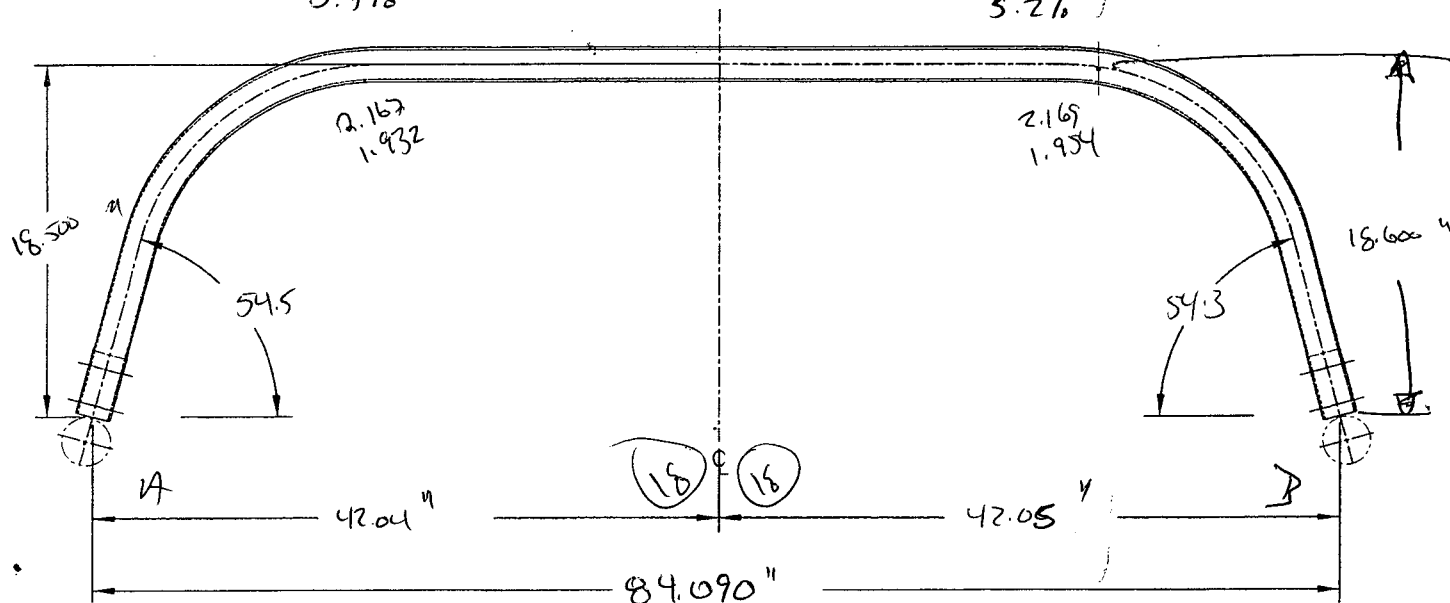
Required Dimension	Min	Max
Height $18.47 \pm .13$	18.340 "	18.600 "
1/2 Span $41.92 \pm .13$	41.79 "	42.05 "
Angle 54 ± 2	54°	56°
Total Span $83.84 \pm .2$	83.590 "	84.090 "

$$.235 \div 4.099$$

$$5.7\%$$

$$.215 \div 4.123$$

$$5.2\%$$



Comments
Side A = 5.7% crushing @ 5×18 Passes
Side B = 5.2% crushing @ 18 Passes

QC15 Inspection	S
Date	12/02/07

Rev	Date	Change	Revised by	Approved
		New Issue		



LIQUID PENETRANT TEST REPORT

P- 12177

PAGE 1 OF 1

CLIENT DNT ACROSPACE DATE 0 FEB 10 2012 TIME AM ☒ PM ☐
ATTENTION LINDA / CHANTEL ACUREN JOB NO. 188-12-C0031
ADDRESS 1270 ABERDEEN ST. POWO NO. N/A
HAWKESBURY ON. WORK LOCATION SAME
ACCEPTANCE STD ASTM 1417/031-038 REV./DATE 2005
PROJECT F.P.T. on CROSS TUBES AND MOUNTS
ITEM(S) EXAMINED (4) CROSS TUBES (5) MOUNTS

JOB DESCRIPTION PROCEDURE NO. LT0002 REV./DATE 2008 TECHNIQUE NO. 14172 REV./DATE 2008
PART NO. SFE RESULTS MATERIAL ALUMINE ALUMINUM THICKNESS VARIABLE
SCOPE WET FLUORESCENT LIQUID PENETRANT INSPECTION WAS
CARRIED OUT ON 100% EXTERNAL SURFACE.

TEST DETAILS

METHOD <input checked="" type="checkbox"/> FLUORESCENT <input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH <input type="checkbox"/> SOLVENT REMOVABLE <input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND <u>MAGNAFLUX</u>	BLACK LIGHT S/N <u>16959</u> <input type="checkbox"/> OUTPUT > 1000 μ W/cm ² <input type="checkbox"/> AMBIENT < 2 fc
PENETRANT <u>2607</u> MINIMUM DWELL TIME <u>45</u> MIN.	LIGHTING EQUIP. <input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT <input type="checkbox"/> OUTPUT <u>100</u> fc @ SURFACE
PENETRANT REMOVER <u>H2O</u> MINIMUM DRY TIME <u>>10</u> MIN.	OTHER <u>LABINO</u>
DEVELOPER <u>SKD 52</u> MINIMUM DWELL TIME <u>10</u> MIN.	LIGHT METER S/N <u>1098866</u> CAL DUE DATE <u>JUL 27 2012</u>
DEVELOPER TYPE <input checked="" type="checkbox"/> NON AQUEOUS <input type="checkbox"/> AQUEOUS <input type="checkbox"/> DRY	

TEST SURFACE

SURFACE CONDITION <input type="checkbox"/> AS GROUND <input type="checkbox"/> AS WELDED <input checked="" type="checkbox"/> MACHINED <input type="checkbox"/> SHOT BLASTED <input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE <input type="checkbox"/> < -4°C/ 20°F <input type="checkbox"/> -4°C/ 20°F TO 10°C/50°F <input checked="" type="checkbox"/> 10°C/50°F TO 52°C/125°F <input type="checkbox"/> > 52°C/125°F

RESULTS- ☒ METRIC ☐ IMPERIAL

5 MOUNTS - W.O. 77271 ✓	
1 CROSS TUBE W.O. 76449 ✓	
1 CROSS TUBE W.O. 76449 ✓	
1 CROSS TUBE W.O. 79629 ✓	
1 CROSS TUBE W.O. 79627 ✓	

Serial 110

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE <u>Andrew Sheldon</u> PRINT <u>ASheldon</u> SIGNATURE	DTR # <u>EG3807</u>
TECHNICIAN (SIGNATURE): <u>Mike I. Husky</u> 1 st TECHNICIAN	REPORT REVIEWED BY:
NAME (PRINT): <u>Mike I. Husky</u> CGSB LEVEL <u>II</u> SNT LEVEL <u>6006</u> CGSB REG. NO. <u>6006</u>	NAME INITIALS
2 nd TECHNICIAN	